

Work Order ID 82015

March-22-12 10:19:56 AM

82015

Page 1

Item ID: D3278-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Assembly
 Start Date: 22/03/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3278 | Rev C | | | | | | | | |

100
100
 Small Fab
 Small Fab
 Small Fab

Small Fab
 Memo
 Rivet spacers with support as per Dwg D3278.

0.00
 0.00

110
110
 QC
 Quality Control

QC5- Inspect part completeness to step on W/O
 Memo

0.00
 0.00

120
120
 Small Fab
 Small Fab
 Small Fab

Small Fab
 Memo
 Assemble support as per Dwg D3278.***DO NOT TIGHTEN BOLTS***Identify as D3278-041

0.00
 0.00

Handwritten signature 12/03/12 (40)

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Handwritten signature 12/03/12 (40)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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March-22-12 10:19:57 AM

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Page 2

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 Start Date: 22/03/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | 100% (40) | | | |
| 140 *140* Packaging Packaging | Identify as per dwg & Stock Location Memo | 0.00 0.00 | | | | | | | |
| 150 *150* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

(40) SP 12-03-30

12/4/12
CL 12/03/30

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 82015

82015

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D3278-1 *D3278-1* Support | | Manufactured | No | | | 100 | Each | 41.0000 | 1 | 40 | ** | 4/5/2/03/23 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | GA | | 41 | | | | | | | |
| | | | | 73412 | | 1 | | | | | | | |
| | | | | 78803 | | 40 | | | 40 | | | | |
| D3278-2 *D3278-2* Support | | Manufactured | No | | | 100 | Each | 41.0000 | 1 | 40 | ** | 4/5/2/03/23 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | CA | | 1 | | | | | | | |
| | | | | 74879 | | 1 | | | | | | | |
| | | | | GA | | 40 | | | | | | | |
| | | | | 78804 | | 40 | | | 40 | | | | |
| D3278-3 *D3278-3* Spacer | | Manufactured | No | | | 100 | Each | 111.0000 | 1 | 40 | ** | 4/5/2/03/23 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | GA | | 111 | | | | | | | |
| | | | | 70984 | | 2 | | | | | | | |
| | | | | 77061 | | 54 | | | 40 | | | | |
| | | | | 80166 | | 55 | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-22-12 10:20:01 AM

Work Order ID: 82015

82015

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 40.00

Required Qty: 40.00

MS21042L4 Purchased No

100 Each 4,937.000 2 80

MS21042L4

Nut

**

EF 12/03/27

Location

Loc Qty

Loc Code

ST300

4937

118451

69

119017

14

119075

2854

121011

2000

80

AN4-13A Purchased No

120 Each 1,277.000 2 80

AN4-13A

Bolt

**

EF 12/03/27

Location

Loc Qty

Loc Code

ST357

1277

119449

59

120187

318

120422

500

120770

400

80

AN960JD416 NAS1149D0463J Purchased No

120 Each 12.0000 4 160

AN960JD416

Washer

**

EF 12/03/27

LD M121011 160x

Location

Loc Qty

Loc Code

ST351

12

116289

12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Picklist Print

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Page 3

Work Order ID: 82015

Parent Item: D3278-041

Parent Item Name: Support Assembly

82015

D3278-041

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 40.00

Required Qty: 40.00

D2230-1

Manufactured No

120

Each

105.0000

2

80

D2230-1

Lug

**

Handwritten: 12/03/27
80

Location

Loc Qty

Loc Code

ST

96

78596

96

ST480

9

67826

6

70974

3

MS20426AD3-6

Purchased

No

120

Each

5,017.000

4

160

MS20426AD3-6

Rivet

**

Handwritten: 12/03/23
160

Location

Loc Qty

Loc Code

ST316

5017

105055

107

116289

2294

120123

2616

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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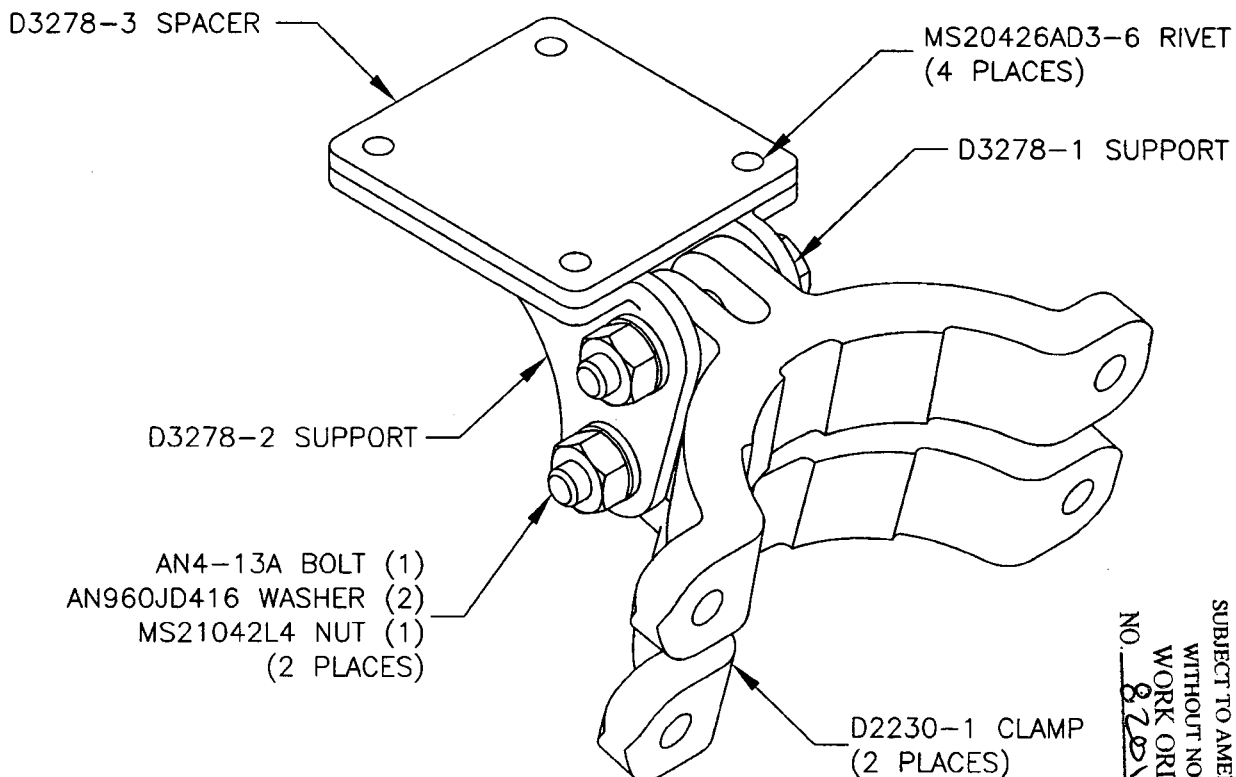
NOTE: Date & initial all entries

DART

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|------------------|----------------|---|------------------------|
| DESIGN 97 | DRAWN BY BC | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED B | APPROVED H | DRAWING NO. D3278 | REV. C SHEET 1 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE NTS |
| A | 04.03.03 | NEW ISSUE | |
| B | 05.03.31 | CHANGE DIM/TOL TO ENSURE FIT | |
| C | 07.07.24 | CHANGED RIVETS PER PAR #185 | |

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



| Qty | Part Number | Description |
|-----|--------------|------------------|
| X | D3278-041 | SUPPORT ASSEMBLY |
| 2 | D2230-1 | CLAMP |
| 1 | D3278-1 | SUPPORT |
| 1 | D3278-2 | SUPPORT |
| 1 | D3278-3 | SPACER |
| 2 | AN4-13A | BOLT |
| 4 | AN960JD416 | WASHER |
| 4 | MS20426AD3-6 | RIVET |
| 2 | MS21042L4 | NUT |

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82015 MLC 12/03/22

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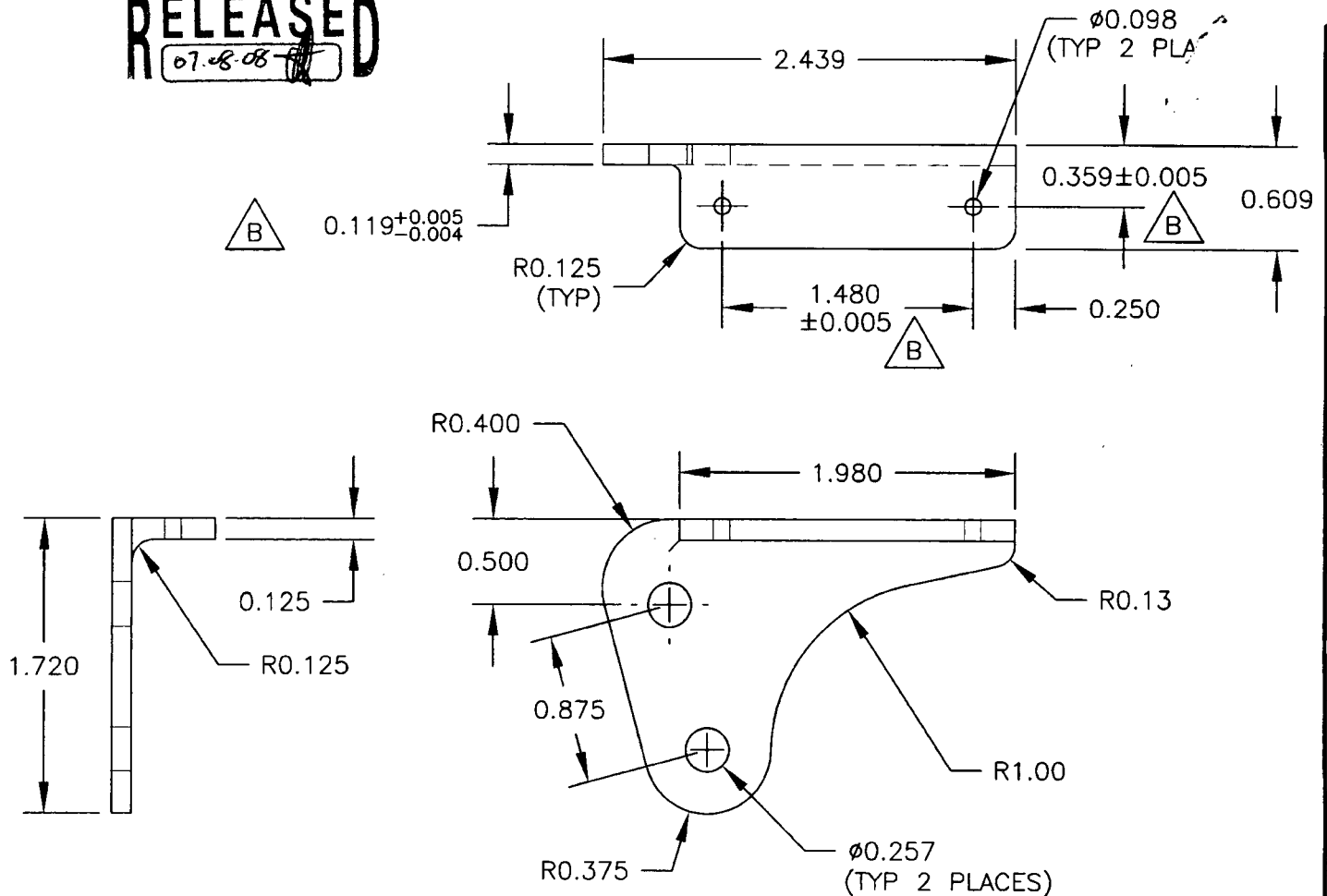
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NOTE: Date & initial all entries

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| DESIGN <i>97</i> | DRAWN BY <i>DC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>B</i> | APPROVED <i>H</i> | DRAWING NO. D3278 | REV. C SHEET 2 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE 1:1 |

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

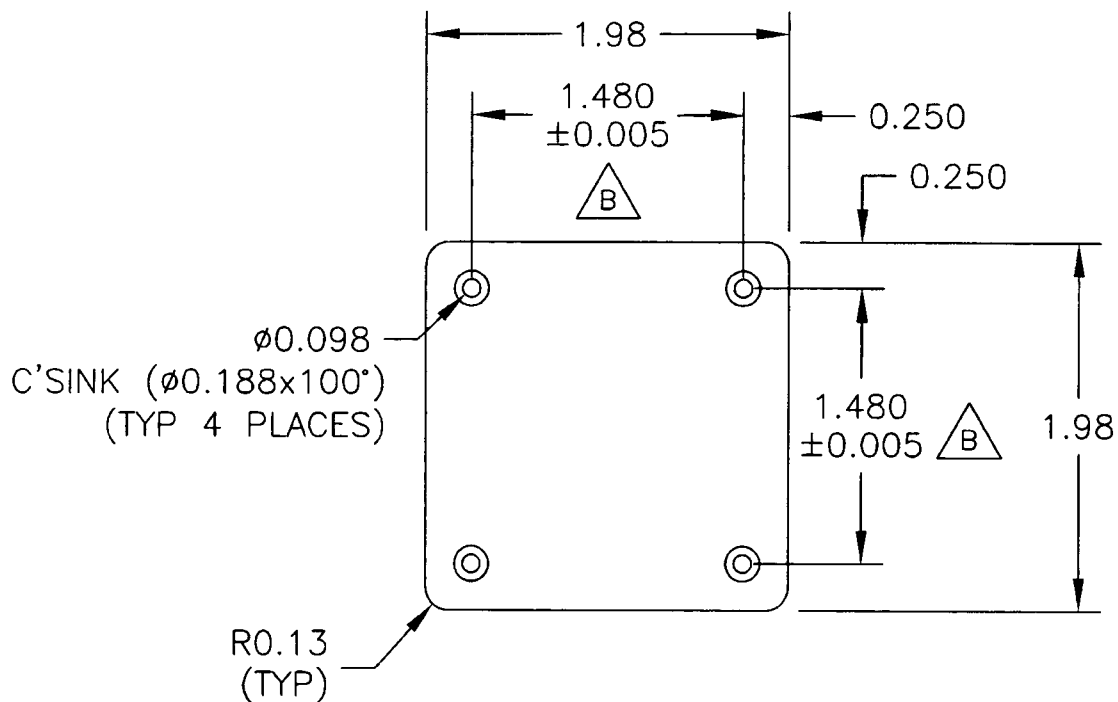
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NOTE: Date & initial all entries

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| DESIGN <i>GP</i> | DRAWN BY <i>DC</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>B</i> | APPROVED <i>H</i> | DRAWING NO. D3278 | REV. C SHEET 3 OF 3 |
| DATE 07.07.24 | | TITLE SUPPORT ASSEMBLY | SCALE 1:1 |

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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